



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C10-12-0
Job Sheet 175735



Part No: C10-12-0

Job Qty: 1 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: At Planning

Priority: High

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-12 Rev 2 IPP Rev A 18.04.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/16/18	4/16/18	0.00	0.00	Start Up Machining-4		 21 MAY 14 2018 MAY 14 2018
100	Mill Conv	1 pcs	4/16/18	4/16/18	0.50	0.20	Mill Conv 2		
110	QC	1 pcs	4/16/18	4/16/18	0.00	0.00	QC2 Machining-5		
120	QC	1 pcs	4/16/18	4/16/18	0.00	0.00	QC8 Machining-5		
130	Packaging	1 pcs	4/16/18	4/16/18	0.00	0.00	Packaging3-2		
140	QC21-SA	1 Ea	4/16/18	4/16/18	0.00	0.00	QC21		

Part Op 100 - 1-Drill hole in shaft. Shaft should be retracted when drilled. Studs facing you rotate shaft COUNTER clockwise to the Descriptions: end of stroke, push shaft into solenoid then drill as per DWG sheet 2 2-Engrave S/N and/or P/N number using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
H-2553-020	Solenoid	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	H-2553-020	1	8	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Plex 5/14/18 8:47 AM Dart.lajeunesse.marie

Container No: S071140



Part: C10-12-0

Job No: 175735

Serial No/Batch: S071140

Revision: 2

Inspector:

Date: 05/14/18

DART AEROSPACE LTD		Work Order:	175735
Description: Solenoid		Part Number:	C10-12-0
Inspection Dwg: Same as PIN.		Rev: 2	Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	Checked by:	QC Inspector:
Date: 18/5/14	Date: MAY 14 2014	Date:

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

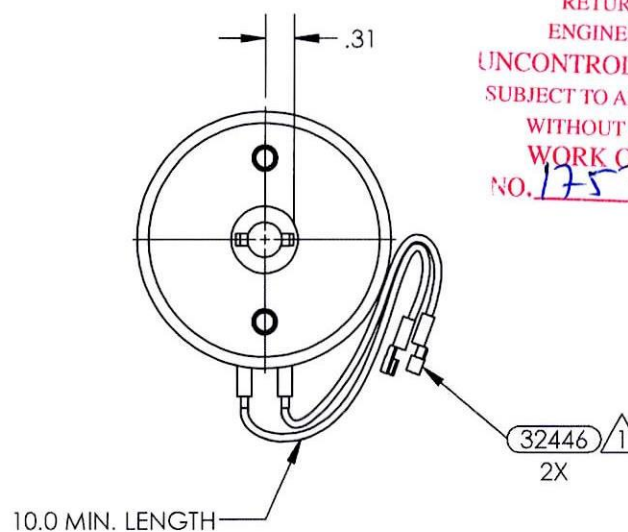
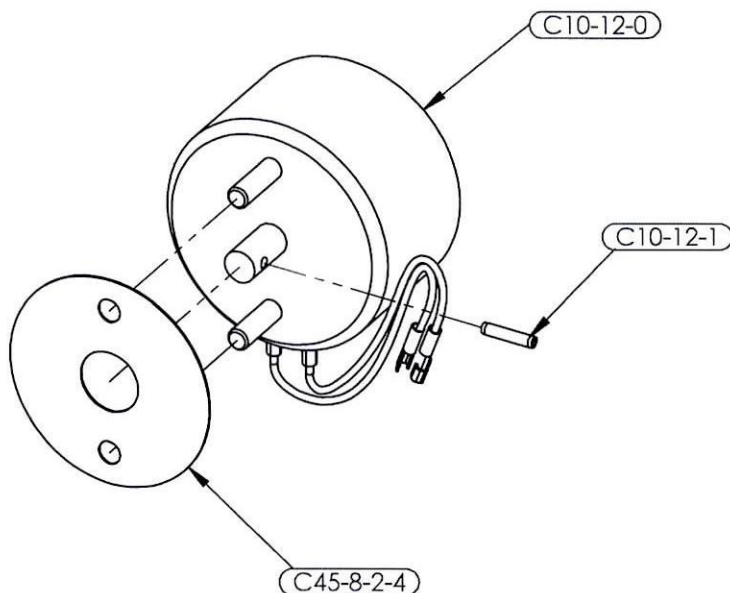
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM	5/13/2013	CFS	
2	14-0090	CH'D TITLEBLOCK WAS RED BARN IS DART. ADDED 10.0 MIN LENGTH NOTE. ADDED SPACER C45-8-2-4, & CONNECTORS 32446. C10-12-0 ADDED ENGRAVE BATCH NUMBER NOTE. C10-12-1 CH'D MAT'L WAS STEEL IS S.S., ADDED B/O INFO #92383A695.	7/25/2014	JAG	RW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 17575 MCL5
18-05-14

NOTE:

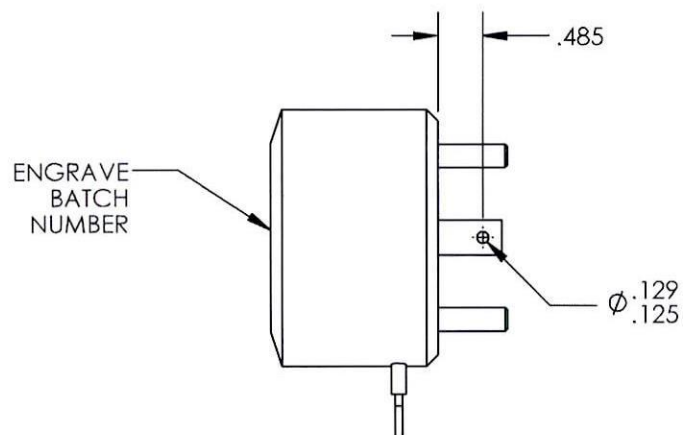
1 CONNECTORS SUPPLIED LOOSE WITH ASSEMBLY.

DART AEROSPACE	
TITLE SOLENOID ASSY	
DWG NO. C10-12	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 4/26/2002 SHEET 1 OF 2

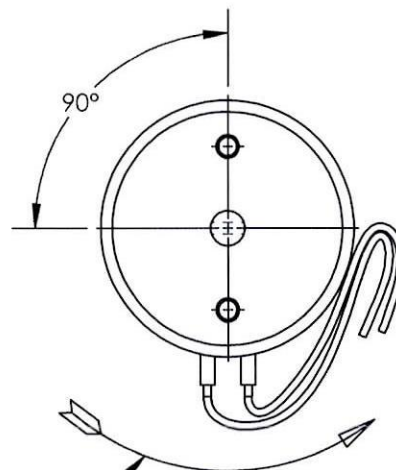
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	C10-12-0	1	SOLENOID		H-2553-020 (MODIFIED)	2
		B/O	C10-12-1	1	SPRING PIN	S.S.	Ø1/8 X 5/8 MCMASTER-CARR #92383A695	1
			C45-8-2-4	1	SPACER		SEE DWG. C45-8-2	1
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		ALLIED ELECTRONICS 32446	1

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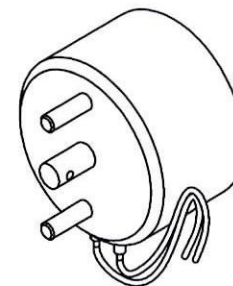
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	01-0090	C10-12-0 ADDED ENGRAVE BATCH NUMBER NOTE.	7/25/2014	DPD	JAG



SHAFT SHOULD
BE RETRACTED
WHEN DRILLED



ROTATE SHAFT COUNTER-CLOCKWISE
(FACING THE STUDS) TO THE END OF STROKE
THEN DRILL AT 90° AS SHOWN.



(C10-12-0)

SOLENOID

DART AEROSPACE	
TITLE SOLENOID ASSY	
DWG NO. C10-12-0	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED: <i>D Weid</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/19/2001
SHEET 2 OF 2	